

5042047



Dart Aerospace Ltd.
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D3488-041
Job Sheet 171966



Part No: D3488-041

Job Qty: 1 ea

Part Name: Blade Fitting LH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/10/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG DSK101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/9/18	0.00	0.00	Start Up Machining-2		MJP 18/02/13
100	Doosan	1 pcs		2/9/18	0.00	0.85	Doosan		MJP 18/02/13
110	QC	1 pcs		2/9/18	0.00	0.00	QC2 Machining-2		MJP 18/02/13
120	CNC Vertical Machining	1 pcs		2/9/18	0.34	0.83	HAAS1-3		
130	QC	1 pcs		2/9/18	0.00	0.00	QC2 Machining-2		
140	QC	1 pcs		2/9/18	0.00	0.00	QC8 Machining-2		
150	HandFinish	1 pcs		2/9/18	0.00	0.03	HandFinish1		
160	Powdercoat	1 pcs		2/10/18	0.00	0.03	Powdercoat1		
170	QC	1 pcs		2/10/18	0.00	0.00	QC3		
180	HandFinish	1 pcs		2/10/18	0.00	0.00	HandFinish4		
190	QC	1 pcs		2/10/18	0.00	0.00	QC5		
200	Packaging	1 pcs		2/10/18	0.00	0.00	Packaging3-1		
210	QC21-SA	1 Ea		2/10/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625
Descriptions: 120 - 1-Machine as per Folio FA625 & Dwg D3488
160 - START TIME: _____
180 - Install Inserts as per Dwg D3488
200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	1 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	4 Ea (4 ea)	180-HandFinish	

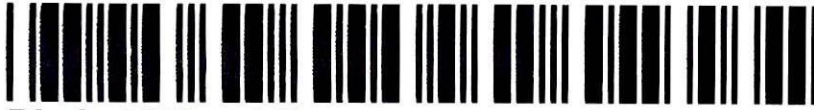
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	1	10	0
180-HandFinish	ALS7-1032-225	4	1,078	0



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Blade Fitting LH

PART NO: D3488 – 041

Original Serial #: S042048

Revision:

Operation: Start up Operation 02/13/18

Change No:

Job No: 171966

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>18-02-13</u>		Step #: <u>100</u>		QTY Effective : <u>①</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				<u>PD 18-02-13</u> Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval <u>PD 18-02-13</u>	
<u>lots of vibration found inside bore</u>				<u>Scrap + destroy</u>					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	☒ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☒	Marks/Chatter ☒	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							